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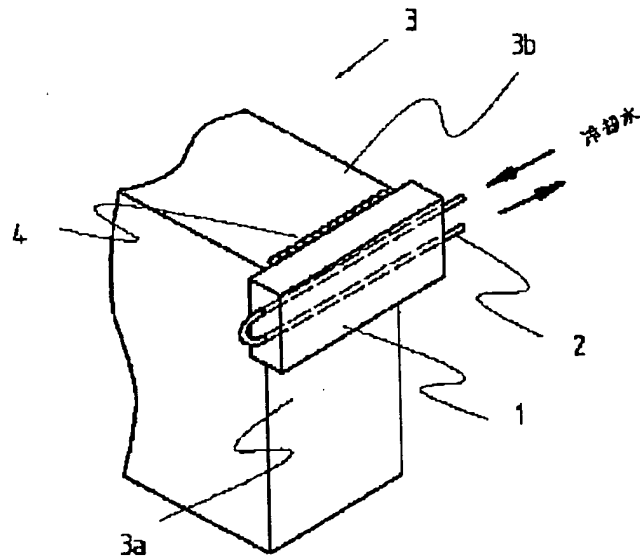
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APPLICANT : JAPAN STEEL WORKS LTD:THE;

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TITLE : CLADDING BY WELDING METHOD OF
SURFACE CORNER AND JIG
THEREFOR



ABSTRACT : PURPOSE: To execute good cladding by welding on the corner part of surface by abutting a jig for cladding by welding for cooling on corner surface side of a material to be welded prior to cladding by welding, successively executing cladding by welding on the corner surface side and separating the jig from the material after a welding bead is solidified.

CONSTITUTION: A jig main body 1 is abutted on a corner part's side surface of a material to be welded as an object of cladding by welding, cooling water is continuously supplied in a tube 2. Under this state, the prescribed cladding by welding is executed on a corner part's upper surface 3b of a material to be welded 3. A welding bead formed by cladding by welding is speedily solidified due to heat absorption to jig preventing generation of droop. The jig is surely cooled by circulating cooling water, preventing temp. rise, the cooling effect of the welding bead is not lowered. The jig is separated from the material to be welded after the welding bead 4 is solidified to an extent not to generate droop, being at any time after the welding bead is solidified.

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